

Work Order ID 69997

Wednesday, May 25, 2011 11:28:46 AM



Page 1

Item ID: D350-636-101

Accept



Setup Start



Revision ID:

Stop



Item Name: Toe Step, LH/RH

Start Date: 5/25/2011 Start Qty: 8.00



Cust Item ID:

Required Date: 6/3/2011 Req'd Qty: 8.00



Customer:

Reference:

Approvals:

Process Plan:

Date: 11-05-25

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3487

Rev A

0.00



DOCUMENT CONTROL

0.00

DC

Memo

Document Control

Photocopy bluefile & type labels per PPPD350-636-101 CHG001

6061 .100

Sub 6/22

→ J for CL 11-6-22

110

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg *** D3487-1***

Dwg Rev:

Prog Rev:

6061 .100

2-Deburr if necessary

11-6-2

(9)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B11-6-2

(9)

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

Sulob603

(x2)

150

NC BRAKE

0.00



Brake NC

Memo

0.00

Brake NC

Form as per Dwg D3487

Sulob603

(7)

(x2)

PTO

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D352-636-101 PAR #: W/P Fault Category: Small FAI3 NCR: Yes No DQA: A Date: 11.06.23
11-688 Resolution: Scrap Disposition: Scrap QA: N/C Closed: ck Date: 11/06/24

NCR: <u>62297</u>		WORK ORDER NON-CONFORMANCE (NCR) <u>\$31.77</u>						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>11/06/16</u>	<u>150</u>	<u>2 pieces crack at the bend K.C Process</u>	<u>11.06.16</u> <u>OS104Z</u> <u>4.2.16</u>	<u>Scrap + destroy</u> <u>Qty x2</u> <u>no replace</u>	<u>SB</u> <u>11/06/16</u>	<u>11.06.16</u> <u>11/06/17</u>	<u>11.06.16</u>	<u>11/06/17</u>

NOTE: Date & initial all entries

Work Order ID 69997

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Start Date: 5/25/2011 Start Qty: 8.00



Cust Item ID:

Required Date: 6/3/2011 Req'd Qty: 8.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8 u106167

(+7)

170

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

7 p 11-6-20

180

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME: 11:30 OVEN TEMPERATURE:
320 FINISH TIME: 1200

7 BK 11-6-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 69997

Wednesday, May 25, 2011 11:28:46 AM



Page 4

Item ID: D350-636-101

Accept



Setup Start



Revision ID:

Stop



Item Name: Toe Step, LH/RH

Start Date: 5/25/2011 Start Qty: 8.00



Cust Item ID:

Required Date: 6/3/2011 Req'd Qty: 8.00

Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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190 Wing Walk as per dwg QSI005 4.4 Batch 117863 0.00



HandFinish

Memo

0.00

Hand Finishing

~~7 0 117863~~
7 0 BR 11.6-21

200 QC3- Inspect Part Finish 0.00



QC

Memo

0.00

Quality Control

7 0 117863

210 Packaging 0.00



Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D350-636-101

Location: _____

PPP Rev: _____

7 0 117863

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Stop



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Cust Item ID:

Required Date: 6/3/2011 Req'd Qty: 8.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

230

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/6/23

ME
11-06-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, May 25, 2011 11:28:52 AM

Page 1

Work Order ID: 69997

Parent Item: D350-636-101

Parent Item Name: Toe Step, LH/RH



Start Date: 5/25/2011


Required Date: 6/3/2011

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP Rev:A New Issue 06-03-03 JLM
11.03.15 now made in house DD verf:JLM

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.100  6061-T6 .100 Sheet		Purchased	No			110	sf	9.5000	0.7942	6.688			



B11-6-2

Location

Loc Qty

Loc Code

MAT021

9.5

102201

9.5

102201

9

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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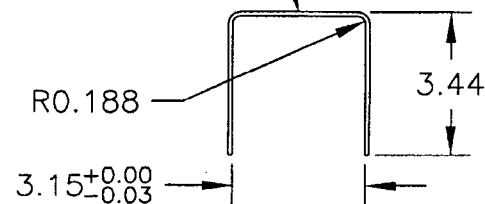
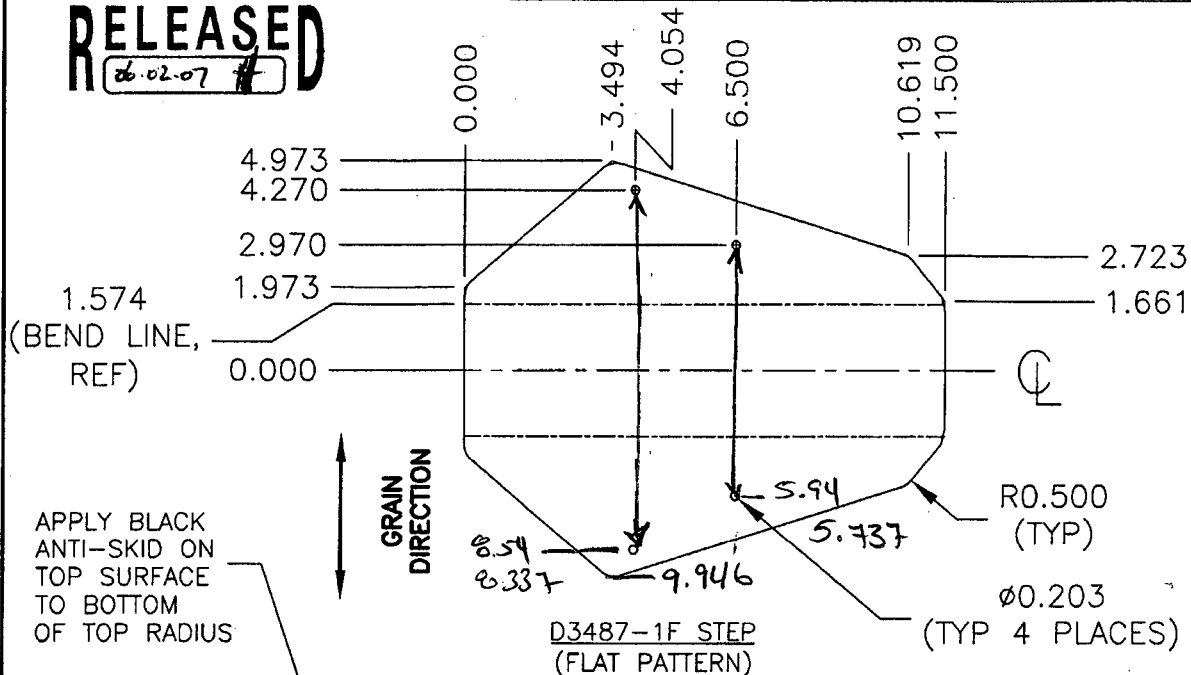
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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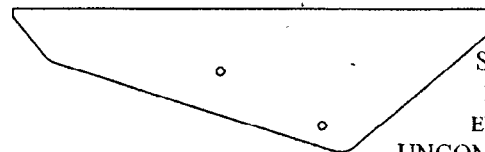
NOTE: Date & initial all entries

DART

DESIGN PH	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED #	APPROVED #	DRAWING NO. D3487	REV. A SHEET 1 OF 1
DATE 06.01.16		TITLE STEP	SCALE 1:4
A	06.01.16	NEW ISSUE	

RELEASED
06.02.07 #

D3487-1 STEP
(BENDING DETAIL)



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 69997
P111-05-25

D3487-1 STEP

- 1) MATERIAL: ALUMINUM 6061-T6/T651 ALUMINUM (QQ-A-250/11) 0.100 THICK
(REF DART MATERIAL SPEC M6061T6S.100)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
* APPLY BLACK ANTI-SKID PAINT TO TOP SURFACE PER DART QSI 005 4.4
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) PART IS SYMMETRICAL ABOUT CENTERLINE
- 6) BREAK UNMARKED EDGES 0.005 TO 0.010 MAX

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